

--23. A method for producing a parison in a parison mold, wherein the parison has a neck, a base and an axially outer sealing edge of the neck, wherein the parison mold has a cavity and a neck mold, the neck mold having a through passage and a neck tool which forms the neck of the parison, and wherein the neck tool has a stop surface, said method comprising the steps of:

(a) introducing a gob of molten glass into said cavity of said parison mold;

(b) pressing a pressing plunger into said gob through the through passage until said pressing plunger reaches an end operating position defined by the stop surface to preliminarily press the parison; and

(c) simultaneously with or following step (b), exerting pressure on the base of the parison with a pressing element, which defines part of the cavity, until the cavity is completely filled with said molten glass and the parison is finished-pressed, wherein the axially outer sealing edge of the neck is completely formed by the pressing plunger.

24. A method according to claim 23, further comprising the steps of:

following step (c), removing the parison mold from the parison, with the exception of the neck tool, and removing said pressing plunger from the parison; and transferring the parison, held by the neck tool at the neck, to a finish-forming station.

25. A method according to claim 23, further comprising the steps of:

contacting said gob with the pressing element within the cavity opposite to said pressing plunger upon the step of pressing said pressing plunger through said through passage and into said gob of molten glass; and

moving said pressing element in a direction out of said cavity, said moving being done by said gob acting on said pressing element.

26. A method according to claim 23, wherein said parison mold comprises longitudinally-divided parison mold halves having a loading orifice formed in a base of said parison mold halves, said method further comprising the steps of:

introducing said gob of molten glass into said cavity through said loading orifice; and

closing said loading orifice with said pressing element.

27. A method according to claim 25, wherein said parison mold comprises longitudinally-divided parison mold halves having a loading orifice formed in a base of said parison mold halves, said method further comprising the steps of:

introducing said gob of molten glass into said cavity through said loading orifice; and

closing said loading orifice with said pressing element.

28. A method according to claim 23, further comprising the steps of:

determining a maximum penetration depth of said pressing element into said cavity by sensing the movement of said pressing element relative to said parison mold; and

controlling the mass of said gob of molten glass introduced into said cavity by sensing the movement of said pressing element relative to said parison mold.

29. A method according to claim 25, further comprising the steps of:

determining a maximum penetration depth of said pressing element into said cavity by sensing the movement of said pressing element relative to said parison mold; and

controlling the mass of said gob of molten glass introduced into said cavity by sensing the movement of said pressing element relative to said parison mold.

30. A method according to claim 26, wherein step (c) is performed by moving said pressing element through said loading orifice into said cavity, and said method further comprising the steps of:

determining the maximum penetration depth of said pressing element into said cavity by sensing the movement of said pressing element relative to said parison mold; and

controlling the mass of said gob of molten glass introduced into said cavity by sensing the movement of said pressing element relative to said parison mold.

31. An apparatus for producing a parison from a gob of molten glass, wherein said parison has a neck, a base, and an axially outer sealing edge, said apparatus comprising:

a parison mold having a cavity, a loading orifice through which said molten gob is received into said cavity, and a neck mold having a longitudinally divided neck tool for forming the neck of the parison, said neck mold having a through passage;

a pressing plunger movable through said through passage for pressing into said glass gob in said cavity, said pressing plunger being movable to an end operating position against the neck mold wherein the pressing plunger lies against

the neck tool, said pressing plunger being configured to completely form said axially outer sealing edge, said pressing plunger being removable from said parison after the parison has been formed; and

a pressing element movable relative to said parison mold and which defines a part of said cavity, said pressing element capable of exerting pressure on the base of said parison in said cavity until said cavity is filled with said molten glass and said parison is finished-pressed, including the formation of the axially outer sealing edge.

32. An apparatus according to claim 31, wherein said parison mold comprises longitudinally-divided parison mold halves, said loading orifice is formed in a base of said parison mold halves, and said pressing element is movable into said cavity through said loading orifice and is capable of closing said loading orifice.

33. An apparatus according to claim 31, wherein said parison mold comprises a non longitudinally-divided block mold which has a locking ring that lies adjacent to the neck tool, wherein said pressing element is displaceably mounted in a lower base orifice of said block mold, and said neck tool in the upwards direction is adjacent to said loading orifice of said block mold.

34. An apparatus according to claim 31 further comprising:

a shaft adjacent to a foot of the pressing plunger, said shaft having an annular end face and is wider than said pressing plunger, and

a forming ring for forming said complete axially outer sealing edge of the neck, said forming ring being formed in said annular end face.

35. An apparatus according to claim 32 further comprising:

a shaft adjacent to a foot of the pressing plunger, said shaft having an annular end face and is wider than said pressing plunger, and

a forming ring for forming said complete axially outer sealing edge of the neck, said forming ring being formed in said annular end face.

36. An apparatus according to claim 33 further comprising:

a shaft adjacent to a foot of the pressing plunger, said shaft having an annular end face and is wider than said pressing plunger, and

a forming ring for forming said complete axially outer sealing edge of the neck, said forming ring being formed in said annular end face.

37. An apparatus according to claim 34, wherein said neck tool includes a stop surface engageable with said end face of said shaft to define said end operating position of said pressing plunger.

38. An apparatus according to claim 35, wherein said neck tool includes a stop surface engageable with said end face of said shaft to define said end operating position of said pressing plunger.

39. An apparatus according to claim 36, wherein said neck tool includes a stop surface engageable with said end face of said shaft to define said end operating position of said pressing plunger.

40. An apparatus according to claim 31 further comprising a cylindrical shaft adjacent to a foot of the pressing plunger, and

a centering ring fixed relative to said parison mold, said cylindrical shaft being received on a last part of the path of the pressing plunger as far as its end operating position in said centering ring so as to be guided and centered in the radial direction through said centering ring.

41. An apparatus according to claim 33 further comprising a cylindrical shaft adjacent to a foot of the pressing plunger, and

a centering ring fixed relative to said parison mold, said cylindrical shaft being received on a last part of the path of the pressing plunger as far as its end operating position in said centering ring so as to be guided and centered in the radial direction through said centering ring.

42. An apparatus according to claim 34 further comprising a cylindrical shaft adjacent to a foot of the pressing plunger, and

a centering ring fixed relative to said parison mold, said cylindrical shaft being received on a last part of the path of the pressing plunger as far as its end operating position in said centering ring so as to be guided and centered in the radial direction through said centering ring.

43. An apparatus according to claim 37 further comprising a cylindrical shaft adjacent to a foot of the pressing plunger, and

a centering ring fixed relative to said parison mold, said cylindrical shaft being received on a last part of the path of the pressing plunger as far as its end operating position in said centering ring so as to be guided and centered in the radial direction through said centering ring.

44. An apparatus according to claim 40 wherein said centering ring is undivided longitudinally and is held radially outwards in a holding groove of the neck tool.

45. An apparatus according to claim 43 wherein said centering ring is undivided longitudinally and is held radially outwards in a holding groove of the neck tool.

46. A method for producing a parison in a parison mold, the parison having a neck, an axially outer sealing edge of the neck and a base, the parison mold having a cavity and a neck mold, the neck mold having a closed, longitudinally-

divided neck tool which forms the neck of the parison, a stop surface, and a through passage, said method comprising the steps of:

(a) introducing a gob of molten glass into said cavity;

(b) pressing a pressing plunger into said gob through said through passage until said pressing plunger reaches an end operating position defined by said stop surface and wherein said pressing plunger lies against the neck mold, wherein the parison mold is preliminarily pressed until the cavity is partially filled with molten glass;

(c) simultaneously with or following step (b), exerting pressure on said base of the parison with a pressing element, which defines part of the cavity, until the parison is finished-pressed; and

wherein the axially outer sealing edge of the neck is completely formed by the pressing plunger.

47. A method according to claim 23, further comprising the steps of:

following step (c), removing said parison mold from the parison, with the exception of said neck tool, and removing said pressing plunger from the parison to allow the parison which is held by the neck tool at the neck to be transferred to a finish-forming station.--

---